

Work Order ID 51047

July 30, 2009 8:31:23 AM



Page 1

Item ID: D350-591-133

Accept



Setup Start



Revision ID: B

Stop



Item Name: Aft Maintenance Step

Start Date: 7/21/09

Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/09

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2946

Rev B

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-133-CHG002

CHG003

8 02/08/10

(P10)

110

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

16 09-07-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
050810	100	chg to chg 003. perm change	R	09.08.14		050810	050810	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51047

July 30, 2009 8:31:23 AM



Item ID:	D350-591-133	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Aft Maintenance Step					
Start Date:	7/21/09	Start Qty:	4.00	Cust Item ID:		
Required Date:	7/21/09	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 80914130			(40)			
130 Large Fab Large Fab	Large Fab Memo 1-Deburr and Bevel ends for welding 2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946 A/RAluminum Rod <u>M11C130</u> <u>M11C972</u> 3-Grind End Cap welds flush	0.00 0.00				4			
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	PB 09.07.30						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-591-133

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Item Name: Aft Maintenance Step

Start Date: 7/21/09

Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/09

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8 09/08/04

44

φ

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

SAD 09-08-04

4

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

M-L 09/08/04

4X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-591-133

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Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/09

Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Large Fab

Large Fab

Memo

0.00

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. □A/R AL ROD BATCH: 1110130*1109-08-04**4*

190

0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

PD 09-08-05

200

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

*⇒ S 08/08/05**(24)**φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

09-08-05

X4

Handwritten signature

Hand Finishing

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

* pressure - wash

09-08-05

X4

Handwritten signature

Powder Coating

START TIME:

2:15pm

OVEN TEMPERATURE:

FINISH TIME:

3200F

1112148 09-08-05

X4

Handwritten signature

230

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

09-08-05

X4

Handwritten signature

Hand Finishing

Wing with

B M 11/2/06

BL 09-08-06. (4)

W/O:		WORK ORDER CHANGES					
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Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

9/8/7 42 SP

250



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

9/8/7 42 SP

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

2) Sorbs/10

40 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

July 30, 2009 8:31:22 AM

Page 1 of 5

Work Order ID: 51047

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 7/21/09

Required Date: 7/21/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2622-120CRevC1

Manufactured

No

110

Each

159.0000

2.0800



Step Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

33

46910

33

Main Warehouse

WA

126

48612

126

Handwritten signature and date: 07-31

4

D2734RevC

Manufactured

No

130

Each

117.0000

8.0000



Step End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

117

43535

2

48110

115

Handwritten signature and date: 07-31

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 51047

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step


Comments:

Start Date: 7/21/09

Required Date: 7/21/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2944RevA  Step Mounting Plate		Manufactured	No			130	Each	23.0000	8.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

23

29351

3

36405

8

36407

12

09.07.31

8

AN4-11A *ty*

Purchased

No



Bolt

250

Each

654.0000

16.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

654

106605

54

110382

600

Each

106605 50

AN4-14A *ty*

Purchased

No



Bolt

250

Each

405.0000

32.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

405

107534

19

110372

386

8 x each

9/8/7 (42) SP

July 30, 2009 8:31:22 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July 30, 2009 8:31:22 AM

Work Order ID: 51047

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 7/21/09

Required Date: 7/21/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-7A		Purchased	No			250	Each	153.0000	8.0000			
--------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 153

108077 3

111668 100

112314 50

111668 SQ

AN960JD416		Purchased	No			250	Each	11,912.00	56.0000			
------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 11912

102929 2

105906 4

107321 23

107939 114

108161 553

108827 31

109249 69

110523 340

111279 776

111916 5000

112314 5000

16941 0

14x
each

111279

9/8/7
SQ (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July 30, 2009 8:31:22 AM

Work Order ID: 51047

Parent Item: D350-591-133RevB

Parent Item Name: Aft Maintenance Step


Comments:

Start Date: 7/21/09

Required Date: 7/21/09

Start Qty: 4.00


Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-1RevF 		Manufactured	No			250	Each	145.0000	16.0000			

Lug

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	145	
22163	0	
48229	145	


48229 SD

D2230-3RevF 		Manufactured	No			250	Each	91.0000	16.0000			
--	--	--------------	----	--	--	-----	------	---------	---------	--	--	--

Lug

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	91	
22121	0	
47965	-2	
48384	93	

48384 SD

D2856-400RevA 		Manufactured	No			250	f	163.4477	5.0400			
--	--	--------------	----	--	--	-----	---	----------	--------	--	--	--

Abraison Strip

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	163.4477	
42437	44.93	
46543	118.5177	

46543 9/8/09 SD

July 30, 2009 8:31:22 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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July 30, 2009 8:31:22 AM

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Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 7/21/09

Required Date: 7/21/09

Start Qty: 4.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2945RevA Step Mounting Plate	71	Manufactured	No			250	Each	7.0000	4.0000			PD →
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>45264</div>												
<div>Loc Qty</div> <div>7</div> <div>7</div>												
<div>Loc Code</div> <div></div>												
MS21042L4 Nut	44	Purchased	No			250	Each	10,282.00	56.0000			9/8/11 45264 SC
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>107499</div> <div>110507</div> <div>111827</div> <div>112314</div> <div>15924</div> <div>8182</div>												
<div>Loc Qty</div> <div>10398</div> <div>5</div> <div>2232</div> <div>6000</div> <div>2000</div> <div>0</div> <div>161</div>												
<div>Loc Code</div> <div>14x each</div> <div>110507</div> <div>9/8/7</div> <div>42</div>												
D2732-030RevB1 Rubber Cushion		Manufactured	No			250	Each	0.0000	8.0000			43118 SV

July 30, 2009 8:31:22 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: JA Date: 09.08.14

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/8/10	250	Missing Parts From Pack List Per DSJ 9459 R.C. not updated correctly. From COS to interactive	BS1412	ADD MISSING PARTS AN4-16A QTY x8 B# 108471	SC 9/7/11	S 09/06/10	BS1412	S 02/08/10
			BS1412	ADJUST BOM + W/LD TO CORRECTLY ADD PARTS FOR NEXT TIME. Also add new BOM FOR REF.	09/08/10	S 09/08/10	BS1412	S 09/08/10
				Was there				

NOTE: Date & initial all entries

DART

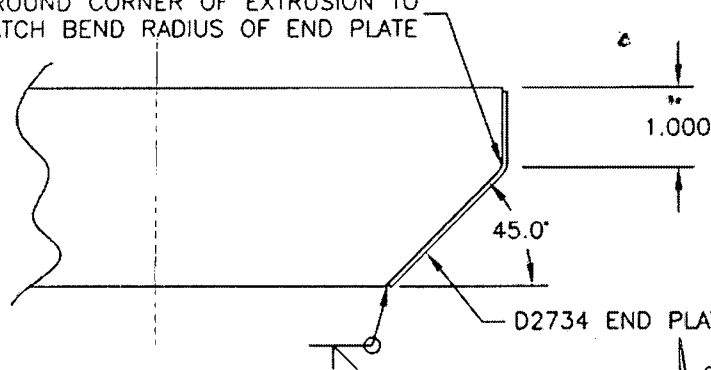
D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

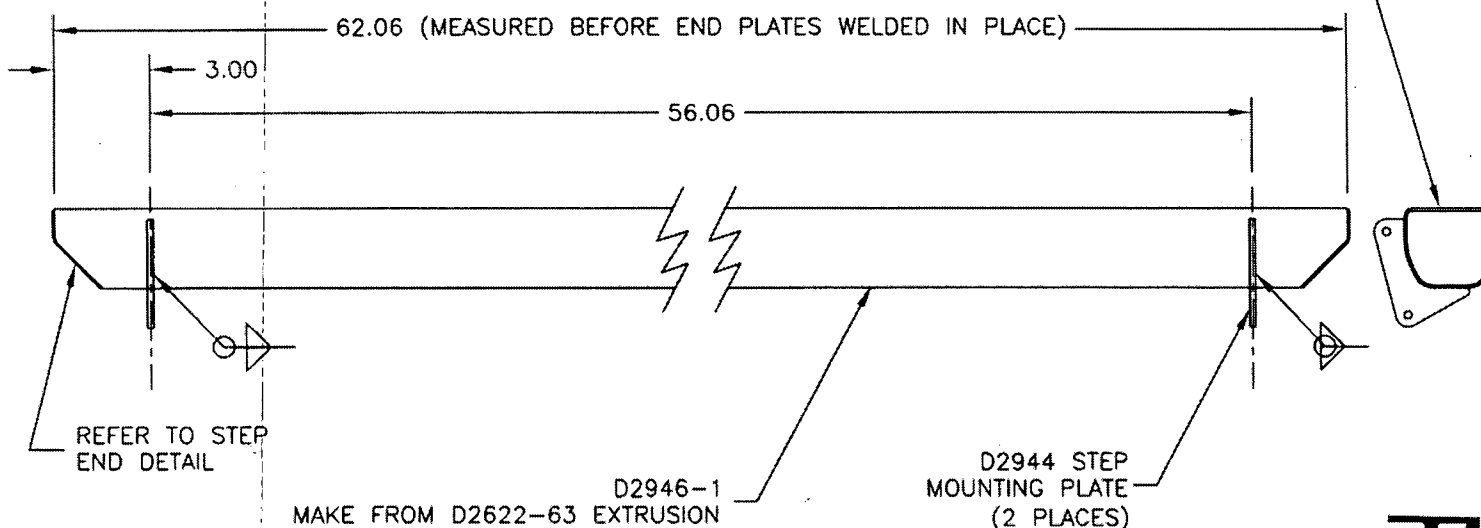
NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.11.14	05.11.14	D2946
DATE	TITLE	SHEET 1 OF 1
05.11.14	STEP ASSEMBLY	SCALE
A	99.12.13	REV. B
B	05.11.14	1:6
UPDATE FINISHING NOTE		

RELEASED
05-11-28

W/O:		WORK ORDER CHANGES					
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Accept

Setup Start

Stop

Item ID: D350-591-133

Revision ID: B

Item Name: Aft Maintenance Step

Start Date: 7/21/09 Start Qty: 4.00

Required Date: 7/21/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2946

Rev B

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-133 CHG002

CL09/08/10

0.00

0.00

please check for chg003

110



Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

16 09.07.30

REFERENCE ONLY

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

REFERENCE ONLY

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Revision: **G**
Date: 08.10.06

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:


Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT,







The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

REFERENCE ONLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS NTS	
DATE	09.06.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Status	Item ID	Rev	Name	Start Date	Quantity Per	UOM	Scrap %	Route Seq ID	Sort	Date Last Mod	Add Date	Comments
<input checked="" type="checkbox"/>	D2622-120C	C1	Step Extrusion	06/24/09	0.5200	Each	0 %	110	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	D2944	A	Step Mounting Plate	06/24/09	2.0000	Each	0 %	130	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	D2734	C	Step End Plate	06/24/09	2.0000	Each	0 %	130	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	AN4-16A		Bolt	08/07/09	8.0000	Each	0 %	250	0	08/07/09 2:32...	08/07/09	
<input checked="" type="checkbox"/>	D2856-400	A	Abraison Strip	06/24/09	1.2600	f	0 %	250	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	AN4-11A		Bolt	06/24/09	4.0000	Each	0 %	250	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	AN960JD416		Washer	06/24/09	14.0000	Each	0 %	250	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	D2230-1	G	Lug	07/30/09	4.0000	Each	0 %	250	0	07/30/09 10:28...	07/30/09	
<input checked="" type="checkbox"/>	AN4-14A		Bolt	06/24/09	8.0000	Each	0 %	250	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	MS21042L4		Nut	06/24/09	14.0000	Each	0 %	250	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	D2945	A	Step Mounting Plate	06/24/09	1.0000	Each	0 %	250	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	D2230-3	G	Lug	07/30/09	4.0000	Each	0 %	250	0	07/30/09 10:29...	07/30/09	
<input checked="" type="checkbox"/>	AN4-7A		Bolt	06/24/09	2.0000	Each	0 %	250	0	07/20/09 2:42...	06/24/09	
<input checked="" type="checkbox"/>	D2732-030	B1	Rubber Cushion	07/20/09	8.0000	Each	0 %	250	0	08/07/09 2:32...	07/20/09	A

→ Was chg

REFERENCE ONLY